

# Aero Design Ltd.

## Work Order Control Sheet

Work Order#: 2017-102 Date Opened: 16 June 2017 Title: Fabrication

Aircraft OEM: Eurocopter Aircraft Model: AS350/AS355 Product Type: Beams Product Model: Forward Quantity: 72

### Work Order Contents

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification (Original)  
Time Sheet (R&D)  
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

### Component Completion

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

70
0
N/A
N/A

### Certification

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Tracking Tags (White) Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
JC
N/A
N/A
N/A
JC

### Additional Documentation

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

JC
N/A
N/A

### Billing

Local (Aero Design)  
Research and Development  
Third Party

JC
N/A
N/A

### Notes

### Sheet Contents

Tasks Initialled  
Dual Inspections Initialled

JC
JC

### Drawing List

Drawing #	Rev #	Description	Initial or N/A
78635	0	Forward Beam	JC

### Traveller

Work performed by:

Print: J. CLARKE

Sign: [Signature]

SCA: A1002

Date: 22 NOV 2018

ICC / Dual Inspection performed by:

Print: J. REKVE

Sign: [Signature]

SCA: A1001

Date: 22 NOV 2018

Work Order closed by:

Print: J. CLARKE

Sign: [Signature]

SCA: A1002

Date: 30 JULY 2019

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

# MOUNTING BEAM FABRICATION – 78635

1-5  
Complete gc.

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

### 78635 – Forward Beam

Work Order: 2017-102

Batch Quantity: 3672  
(5 max, use additional sheets for more)

Complete  
(initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.



#1	#2	#3	#4	#5
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05

## 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
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## 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
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## 6. CNC Machining

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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## 7. Beam Welding

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	10	10	10

## 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

## 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02
			paint	paint

## 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02



# MOUNTING BEAM FABRICATION – 78635

6-10  
Complete fr.

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

### 78635 – Forward Beam

Work Order: 2017-302

Batch Quantity: 3672  
(5 max, use additional sheets for more)

Complete  
(initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

#1	#2	#3	#4	#5
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05

## 4. Beam Welding

- a. TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- b. Record component and welding rod POs / WOs on attached material list.
- c. Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
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## 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- a. Set beam on blocks as far apart as possible on hydraulic press.
- b. Use a 2" block to distribute press loads.
- c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- d. Check for straight with a straight edge on back of tube.
- e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- f. Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
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## 6. CNC Machining

- a. Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- b. De-burr keyways and slots.
- c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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## 7. Beam Welding

- a. TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- b. TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- c. TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- d. TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- e. Record component and welding rod POs / WOs on attached material list.
- f. Tag in-progress parts and place on in-progress shelf in welding shop for straightening.



#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	10	10	10

## 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.

# MOUNTING BEAM FABRICATION – 78635

11-15  
Complete JC.

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

### 78635 – Forward Beam

Work Order: 2017-102

Batch Quantity: 3672  
(5 max, use additional sheets for more)

Complete  
(initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.



#1	#2	#3	#4	#5
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05

## 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
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## 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
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## 6. CNC Machining

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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## 7. Beam Welding

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	10	10	10

## 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.



# MOUNTING BEAM FABRICATION – 78635

16-20  
complete

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

### 78635 – Forward Beam

Work Order: 2017-102

Batch Quantity: 3672  
(5 max, use additional sheets for more)

Complete  
(initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

# MOUNTING BEAM FABRICATION -78634-01

Complete  
(initial or SCA #)

#1	#2	#3	#4	#5
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05

## 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
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## 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
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## 6. CNC Machining

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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## 7. Beam Welding

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.



#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	10	10	10

**8. Beam Finishing**

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

**9. Final Inspection**

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

**10. Powder Coating**

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

**11. Final Assembly**

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

# MOUNTING BEAM FABRICATION – 78635

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

### 78635 – Forward Beam

Work Order: 2017-10.2

Batch Quantity: 3672 Complete  
(5 max, use additional sheets for more) (initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.



#1	#2	#3	#4	#5
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05

## 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

## 5. Beam Straightening

AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
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Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

## 6. CNC Machining

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 10
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- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

## 7. Beam Welding

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	02	02	02

## 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

AD	AD			
73-04	73-04			
02	02	OK	OK	OK

## 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.



# MOUNTING BEAM FABRICATION – 78635

Complete 26-30

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

## 78635 – Forward Beam

Work Order: 2017-102

Batch Quantity: 3672

Complete  
(initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

### 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

### 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

### 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	10	10	10

## 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	10	10	10

## 6. CNC Machining

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 7. Beam Welding

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.



Complete  
(initial or SCA #)

#1 AD 73-04 02	#2 AD 73-04 02	#3 AD 73-04 02	#4 AD 73-04 02	#5 AD 73-04 02
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## 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

## 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02

## 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02

## 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.

AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02

# MOUNTING BEAM FABRICATION – 78635

Complete

31-35

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

### 78635 – Forward Beam

Work Order: 2017-102

Batch Quantity: 36 72 Complete  
(5 max, use additional sheets for more) (initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.



#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	10	10	10

## 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	10	10	10

## 6. CNC Machining

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 7. Beam Welding

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

## 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

AD	AD	AD	AD	AD
73-01	73-01	73-01	73-01	73-01
01	01	01	01	01

## 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02



## MOUNTING BEAM FABRICATION – 78635

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

## 78635 – Forward Beam

Work Order: 2017-102Batch Quantity: 72

Complete

(5 max, use additional sheets for more) (initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

# MOUNTING BEAM FABRICATION –78634-01

Complete

(initial or SCA #)

#1 AD 73-04 05	#2 AD 73-04 05	#3 AD 73-04 05	#4 AD 73-04 05	#5 AD 73-04 05
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## 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
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## 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
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## 6. CNC Machining

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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## 7. Beam Welding

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.



## MOUNTING BEAM FABRICATION –78634-01

Complete

(initial or SCA #)

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

### 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

AD	AD	AD	AD	AD
73-01	73-01	73-01	73-01	73-01
01	01	01	01	01

### 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

### 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

### 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.

# MOUNTING BEAM FABRICATION – 78635

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

### 78635 – Forward Beam

Work Order: 2017-102

Batch Quantity: 72

Complete

(5 max, use additional sheets for more)

(initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

#### 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.



# MOUNTING BEAM FABRICATION –78634-01

Complete

(initial or SCA #)

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	10	10	10

## 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	10	10	10

## 6. CNC Machining

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 7. Beam Welding

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

# MOUNTING BEAM FABRICATION –78634-01

Complete  
(initial or SCA #)

#1	#2	#3	#4	#5
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

## 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

## 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

#1	#2	#3	#4	#5
AD 73-01 01	AD 73-01 01	AD 73-01 01	AD 73-01 01	AD 73-01 01

Entered in Error 9 Feb 18

## 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

#1	#2	#3	#4	#5
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

## 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.

#1	#2	#3	#4	#5
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02



## MOUNTING BEAM FABRICATION – 78635

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78635 – Forward BeamWork Order: 217-102Batch Quantity: 72

Complete

(5 max, use additional sheets for more)

(initial or SCA #)

Date Open: 16 MNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

# MOUNTING BEAM FABRICATION -78634-01

Complete  
(initial or SCA #)

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	10	10	10

## 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
10	10	10	10	10

## 6. CNC Machining

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 7. Beam Welding

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

## MOUNTING BEAM FABRICATION –78634-01

Complete  
(initial or SCA #)

#1	#2	#3	#4	#5
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

### 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

### 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

AD  
73-04  
02

### 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD  
73-04  
02

### 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.

AD  
73-04  
02



Complete

56-60

## MOUNTING BEAM FABRICATION – 78635

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

## 78635 – Forward Beam

Work Order: 2017-102Batch Quantity: 72

Complete

(5 max, use additional sheets for more)

(initial or SCA #)

Date Open: 16 JUNE 2017

## 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

# MOUNTING BEAM FABRICATION -78634-01

Complete  
(initial or SCA #)

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

## 6. CNC Machining

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 7. Beam Welding

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

# MOUNTING BEAM FABRICATION –78634-01

Complete  
(initial or SCA #)

#1	#2	#3	#4	#5
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

## 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

## 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

AD 73-04 01	AD 73-04 01	AD 73-04 01	AD 73-04 01
-------------------	-------------------	-------------------	-------------------

## 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
-------------------	-------------------	-------------------	-------------------	-------------------

## 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
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## MOUNTING BEAM FABRICATION – 78635

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

## 78635 – Forward Beam

Work Order: 2017-102Batch Quantity: 72  
(5 max, use additional sheets for more)

Complete

(initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

# MOUNTING BEAM FABRICATION -78634-01

Complete  
(initial or SCA #)

#1 AD 73-04 05	#2 AD 73-04 05	#3 AD 73-04 05	#4 AD 73-04 05	#5 AD 73-04 05
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## 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 02
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## 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

73-04 10	AD 73-04 10	73-04 10	AD 73-04 10	AD 73-04 02
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## 6. CNC Machining

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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## 7. Beam Welding

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

# MOUNTING BEAM FABRICATION –78634-01

*used for display, not released*  
↓

**Complete**  
(initial or SCA #)

#1	#2	#3	#4	#5
AD 73-04 02	OK	AD 73-04 02	AD 73-04 02	AD 73-04 02

## 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

## 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

AD 73-04 01	N/A OK	AD 73-04 01	AD 73-04 01	AD 73-04 01
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## 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD 73-04 02	N/A OK	AD 73-04 02	AD 73-04 02	AD 73-04 02
-------------------	--------	-------------------	-------------------	-------------------

## 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.

AD 73-04 02	N/A OK	AD 73-04 02	AD 73-04 02	AD 73-04 02
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*Entered in error.*



## MOUNTING BEAM FABRICATION – 78635

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78635 – Forward BeamWork Order: 2017-102Batch Quantity: 72  
(5 max, use additional sheets for more) Complete  
(initial or SCA #)Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

## MOUNTING BEAM FABRICATION –78634-01

Complete  
(initial or SCA #)

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

### 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

### 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

### 6. CNC Machining

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

NR	NR	NR	NR	NR	AD
73-04	73-04	73-04	73-04	73-04	73-04
02	02	02	02	02	02

### 7. Beam Welding

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

# MOUNTING BEAM FABRICATION –78634-01

Complete  
(initial or SCA #)

#1	#2	#3	#4	#5
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

## 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

## 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

AD AD AD AD AD

## 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

PAINT  
AD AD AD AD AD  
73-04 73-04 73-04 73-04 73-04  
02 02 02 02 02

## 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.

AD AD AD AD AD  
73-04 73-04 73-04 73-04 73-04  
02 02 02 02 02



## MOUNTING BEAM FABRICATION – 78635

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78635 – Forward BeamWork Order: 2017-102Batch Quantity: 72

Complete

(5 max, use additional sheets for more)

(initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

# MOUNTING BEAM FABRICATION -78634-01

Complete  
(initial or SCA #)

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 4. Beam Welding

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 5. Beam Straightening

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

## 6. CNC Machining

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 7. Beam Welding

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

NR	NR	NR	NR	NR
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

# MOUNTING BEAM FABRICATION –78634-01

Complete  
(initial or SCA #)

#1	#2	#3	#4	#5
AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

## 9. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

## 10. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD	AD	AD	AD
73-04	73-04	73-04	73-04
02	02	02	02

## 11. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02



Complete 71-72

# MOUNTING BEAM FABRICATION – 78635

## General

These instructions apply to mounting beams 78635-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

## 78635 – Forward Beam

Work Order: 2017-102

Batch Quantity: 72

Complete

(5 max, use additional sheets for more)

(initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
			AD	AD
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>73-04</u>	<u>73-04</u>
			<u>02</u>	<u>02</u>

### 1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.065 material as indicated on drawings.
  - 78634-02 – 24.25"
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

### 2. CNC Machining

- Run CNC programs to machine slots and holes in 78635-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

Damaged due to coolant problem  
scrapped

### 3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78634-04.
- Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- Cut and turn 69830-11 guide tubes from 3/4 x 0.065 tube.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

## MOUNTING BEAM FABRICATION -78634-01

Complete  
(initial or SCA #)

	#1	#2	#3	#4	#5
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## 4. Beam Welding

N/A N/A N/A N/A N/A

- TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
  - Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

## 5. Beam Straightening

N/A N/A N/A N/A N/A

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- Set beam on blocks as far apart as possible on hydraulic press.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

## 6. CNC Machining

N/A N/A N/A N/A N/A

- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

## 7. Beam Welding

N/A N/A N/A N/A N/A

- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
- TIG weld 69830-11 block to 78634-02 tube over 3<sup>rd</sup> keyway (see drawing) using ER308L rod.
- TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

# MOUNTING BEAM FABRICATION -78634-01

Complete  
(initial or SCA #)  
#1 #2 #3 #4 #5

## 8. Beam Finishing

N/A N/A N/A N/A N/A

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

## 9. Final Inspection

N/A N/A N/A N/A N/A

To be completed by a different person than the previous steps.

- Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- Tag in-progress parts ready for powder coating.

## 10. Powder Coating

N/A N/A N/A N/A N/A

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

## 11. Final Assembly

N/A N/A N/A N/A N/A

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- If maintenance step is to be installed: Install stops above into BOTH guides per b and c.
- Adhere P/N placard to back surface of beam.
- Green tag complete beam assembly and place into stock.



Work Order: 2017-102Material Tracking Sheet  
Eurocopter AS350/AS355 Forward Mounting Beam

1 of 2

Date Opened: 16 June 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
-2	72		78635-01-00	Forward Beam Assembly		
Step 1				Fabrication		
	1		78634-02	Tube	1x2x0.065 Tube, 304 Stainless Steel	17050
Step 2				Machning	None	
Step 4				Fabrication		
	3		78634-03	Pad	1x0.125 Bar, 304 Stainless Steel	16085
	1		78634-11	Pad	1x0.125 Bar, 304 Stainless Steel	16085
	1		78634-12	Pad	1x0.125 Bar, 304 Stainless Steel	16085
	1		78634-04	Cap	0.050" Sheet, 304 Stainless Steel	3021
	4		78630-04	Bushing	0.375 x 0.065 Tube, 304 Stainless Steel	2017-77
	2	69830	69830-11	Guide	0.75 x 0.065 Tube, 304 Stainless Steel	2016-79/ 2017-148(9)
Step 6				Welding		
	A/R	--	--	Welding Rod	ER308L	17066
Step 7				Straightening	None	
Step 8				Machning	None	
Step 10				Welding		
	A/R	--	--	Welding Rod	ER308L	17066
Step 11				Finishing	None	
Step 12				Final Inspection	None	
Step 13				Powder Coating		

17118 (3) / 1747 (4)

BLK

18019 (4)  
BLK18037 (1)  
BLK18047 (2)  
OFF-WHITE17074 / 17055 / 17068 / 17105  
(2) (4) (2) (3) (10)  
Red white black  
18074 (1) 18052 (2)  
BLK BLU

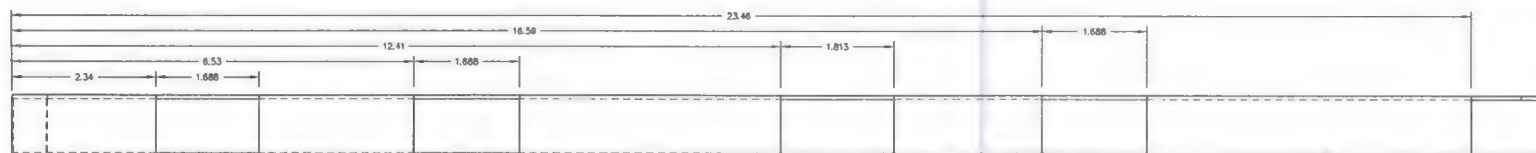
Work Order: 2017-102Material Tracking Sheet  
Eurocopter AS350/AS355 Forward Mounting Beam

2 of 2

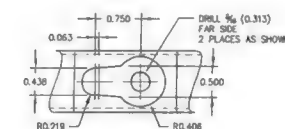
Date Opened: 16 JUNE 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
<b>Step 15</b>				<i>Final Assembly</i>		
	. 2	69830	69830-21	Stop	0.625 Rod, 6061-T6 Aluminum	SEE PDS
	. 2	69830	69830-22	Knob	0.75 Rod, 6061-T6 Aluminum	SEE PDS
	. 2	69830	69830-23	Spring	15mm x 70mm Spring, Stainless Steel	SEE PDS
	. 2		69830-1032X3	3" #10-32 C'sunk screw	Stainless Steel	SEE PDS
	. 2		MS21044C3	Nut		SEE PDS
	. 1		--	P/N Placard	TZ Tape, 1/2", black on white	SEE PDS

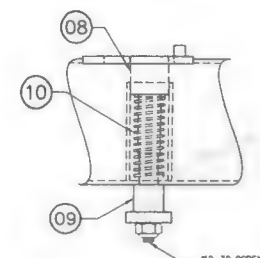
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR PRODUCTION, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR ABUSE, OF THE DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 78634, REV. 1, WELD ADDED TO GUIDE TUBE		



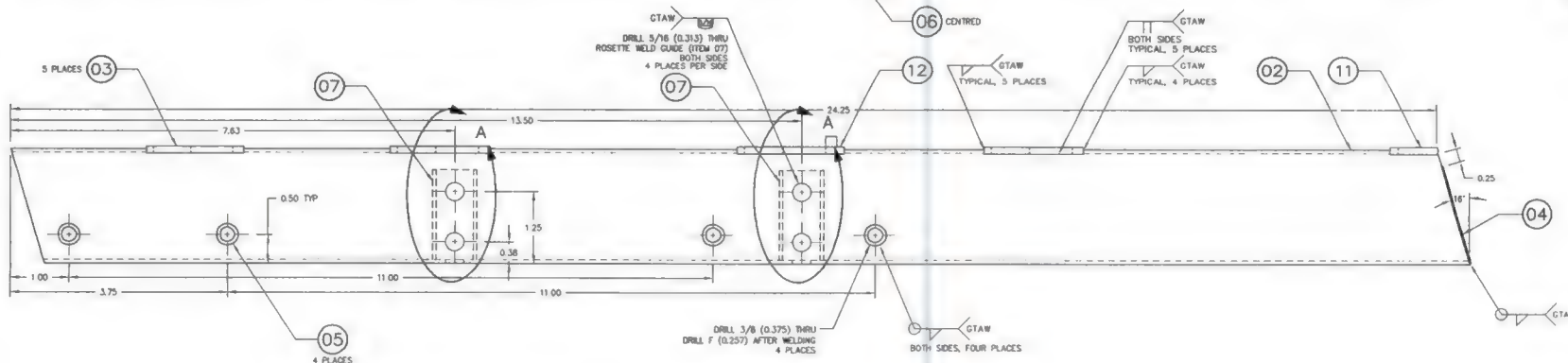
TOP VIEW PRIOR TO WELDING



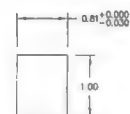
DETAIL B  
TYPICAL, ALL KEYWAYS



DETAIL A  
ASSEMBLY AFTER FINISHING



01 78635-01-00 BEAM ASSEMBLY



11 PAD



12 PAD



04 CAP



05 BUSHING



03 PAD

# NOTES

- 1 REMOVE ALL BURRS AND BREAK SHARP EDGES
- 2 WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT
- 3 FINISH ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO ASSEMBLY. ALTERNATE: ALL STEEL PARTS TO BE THOROUGHLY DEGREASED, PRIMED AND PAINTED PRIOR TO ASSEMBLY

1	78634-12	12	PAD	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	78634-11	11	PAD	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
2	MS21044C3		NUT			
2	#10-32		C-SUNK SCREW	STAINLESS STEEL	COMMERCIAL	
2	69830-23	10	SPRING	STAINLESS STEEL	COMMERCIAL	15mm X 70mm SPRING
2	69830-22	09	KNOB	6061-T6 ALUMINUM	QQ-A-200/B	#0.75 ROD
2	69830-21	08	STOP	6061-T6 ALUMINUM	QQ-A-200/B	#0.625 ROD
2	69830-11	07	GUIDE	304 STAINLESS STEEL	ASTM A269	#0.75 X 0.065 RND. TUBE
1	69830-07	06	BLOCK	304 STAINLESS STEEL	ASTM A479	2 INCH RND. TUBE
4	78630-04	05	BUSHING	304 STAINLESS STEEL	ASTM A269	#0.375 X 0.085 RND. TUBE
1	78634-04	04	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
3	78634-03	03	PAD	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	78634-02	02	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.065 TUBE
78635-01-00 BEAM ASSEMBLY						
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS						

APPROVALS	DATE
DRAWN: JEFF CLARKE	08 SEPT 2018
CHECKED: JASON REKVE	08 SEPT 2018
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

APPROVALS		DATE
DRAWN: JEFF CLARKE		08 SEPT 2018
CHECKED: JASON REKVE		08 SEPT 2018
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		
DECIMALS		
X.XXX ±0.010		
X.XX ±0.03		
X.X ±0.1		
ANGLES		
±1/2°		
SCALE 1:1	DWG. SIZE	DWG. NO.
SHEET 1 OF 1	A1	78635
		0

**AERO DESIGN LTD.**  
8888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G5  
TEL: 604.483.3270 www.aerodesign.ca

**AIRBUS HELICOPTERS AS350 & AS355 SERIES**  
ATTACHMENT PROVISION  
FORWARD BEAM FABRICATION





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 FWD Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: 73635 - 01-00 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-102

Remaining Tasks to be Performed: clean up ✓, straighten ✓  
+ Powder / See Reverse

Signature: *David Mart* AD  
73-04

Date: 17/12/04 Lic. No. / SCA 05

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

### Remarks

Part used on display rack  
not for A/C use. / Feb 8 / 2018  
AD-05



# Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: FORWARD BEAM (A350) No. of pieces: 72

Manufacturer: AERO DESIGN LTD.

Part No.: 78635-01-00 Serial/Batch No.: P017050 (tube)

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-102

Remaining Tasks to be Performed: MACHINING, WELDING, MACHINING  
WELDING, INSPECTION, POWDER COAT

Signature: Jff C. L.

Date: 24 JUL 2017 Lic. No. / SCA A002

In Process





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

### Remarks

-2 Calant problem, stock damaged. - SCRAPPED J. 24 July 2017



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BUSHING No. of pieces: 530

Manufacturer: Aero Design

Part No.: 78630-04 Serial/Batch No.: NSV

TTSN: NP TSO: NA Rem.: NA

Work Order No.: 2017-123

Remaining Tasks to be Performed: debur

\_\_\_\_\_

\_\_\_\_\_

Signature: [Signature]

Date: JULY 31, 2017

Lic. No. / SCA \_\_\_\_\_

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**In Process**

### Remarks

Parts de barred J

rev - welding





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Guide

No. of pieces: 110

Manufacturer: Aero Design

Part No.: 69830-11

Serial/Batch No.: 15073

TTSN: N/A

TSO: N/A

Rem.: N/A

Work Order No.: 2016-79

Remaining Tasks to be Performed: Instal

Signature: David Dwyer

Date: June 10/2016

Lic. No. / SCA

In Process

NO  
73-04  
05



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

**In Process**

**Remarks**

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# Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Fairview beam 654 2 ft

Manufacturer: Aero Design

Part No.: 75635-01-00 Serial / Batch No.: MS.N

TTSN: N/A TSO: N/A Rem.: N/A

Removed From: Structure

Reason For Removal: Cracked Stapes mounting bracket  
and other parts of the

A/C Hours at Removal:                      WO# 2117-102

Signature: [Signature]

Date: July 6 2017 Lic. No. / SCA                     

Unserviceable





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Unserviceable

### Remarks

22  
+1 1000000 did not service fully

PARTS REQUIRED 24 July 2011 J



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**In Process**

**Remarks**

Green tag issued



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Pad No. of pieces: 127

Manufacturer: Aero Design

Part No.: 78634-03 dk Serial/Batch No.: NSN

TTSN: NP TSO: N/A Rem.: N/A

Work Order No.: 2017-102

Remaining Tasks to be Performed: Clean up / Debur

Signature: [Signature]

Date: 19 Jun 17 Lic. No. / SCA AD01

In Process

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0309</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>2</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>12 Aug 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

**BLACKCOMB HELICOPTERS**





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: FWD. Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102

Remaining Tasks to be Performed: See Book

Signature: [Signature]

Date: Aug 11 / 2017 Lic. No. / SCA 78-01 05

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 8, ✓

9, ✓

10, ✓

11, ✓

PAINTED 11 Aug 2017 JC

A

Description: Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: FWD BEAM (A530) No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 78635-01-00 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-102

Remaining Tasks to be Performed: POWDER COAT

Signature: Jff Cee

Date: 09 AUG 2017 Lic. No. / SCA A002

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

In Process

### Remarks

PAINTED 11 AUG 2017 *2*.

## Aero Design

### Parts Distribution Sheet

Blackco MB Heli  
12/08/17

**Description:** Beam Pin

WO#[illegible]



WO# \_\_\_\_\_

Approved Manufacturing Facility 73-04      Form 20.F.06      Rev. Original 27 May 2013



1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0293</b>	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>	
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>2</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12  Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>03 Aug 2017</b>		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

**AIR ZERMATT**

03/04/17

WO#

78635-01-00

03/08/17



**Description:** Beam Pin

WO#

[illegible]

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE <b>FORM ONE</b>			3. Form Tracking No. <b>2017-0298</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks <b>Black</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<del>14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12          Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.</del>		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		<del>14b. Signature 14c. Approved Organization Number</del>	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>09 Aug 2017</b>		<del>14d. Name 14e. Date (dd/mmm/yyyy)</del>	
<b>Installer Responsibilities</b> This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

WTS AVIATION



WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

## Aero Design

### Parts Distribution Sheet

Description: Beam Pin

WO#[illegible]

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0327</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>2</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks <b>Red</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>07 Sep 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

Blackcomp Heli



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Fwd. Beam No. of pieces: 1  
Manufacturer: Aero Design Ltd  
Part No.: 78635-01-00 Serial/Batch No.: NA  
TTSN: NA TSO: NA Rem.: NA  
Work Order No.: 2017-102  
Remaining Tasks to be Performed: See Back

Signature: [Signature]  
Date: Aug 9/2017 Lic. No. / SCA 7304

In Process





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

### Remarks

Steps: 8. ✓

9. ✓

10. ✓

11. ✓

Powder Red 17074



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Fwd. Beam No. of pieces: 1

Manufacturer: Aero Design Ltd

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102

Remaining Tasks to be Performed: See Back

Signature: [Signature]

Date: Aug 9/2017 Lic. No. / SCA AD 73-04 05

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

### Remarks

Steps: 8. ✓

9. ✓

10. ✓

11. ✓

Powder Red 17074

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013





WO# \_\_\_\_\_

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013

WO#

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013



**Description:** Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0339</b>	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>	
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>2</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mm/yyyy) <b>11 Sep 2017</b>		14d. Name		14e. Date (dd/mm/yyyy)
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

*Solo Helicopters*





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 FWD Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102-11

Remaining Tasks to be Performed: Drill, clean up,  
straighten, inspect, powder coat.

Signature: David Party

Date: August 21, 2017 Lic. No. / SCA 73-04  
05

In Process



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

**In Process**

**Remarks**

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**Description:** Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



WO#

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 FWD Brn No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102-10

Remaining Tasks to be Performed: Drill, clean up,  
straighten, inspect, powder coat.

Signature: David M. [Signature]

Date: August 21/2017 Lic. No. / SCA AD 73-04 05

In Process



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

**In Process**

**Remarks**

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WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



**Description:** Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE <b>FORM ONE</b>			3. Form Tracking No. <b>2017-0357</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.			<del> 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12.  Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. </del>		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		<del>14b. Signature</del> <del>14c. Approved Organization Number</del>	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>20 Sep 2017</b>		<del>14d. Name</del> <del>14e. Date (dd/mmm/yyyy)</del>	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

*ACCESS HELICOPTERS*



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 FWD Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102-09

Remaining Tasks to be Performed: Drill, clean up,  
straighten, inspect, powder coat.

Signature: David Hart

Date: August 21/2017 Lic. No. / SCA AD 73-04 05

In Process



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**In Process**

**Remarks**

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WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013





Description: Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0361
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice WO 2017-102
6. Item 1.	7. Description Forward Beam	8. Part Number 78635-01-00	9. Qty. 1	10. Serial/Batch No. N/A	11. Status/Work New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke</i> AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 21 Sep 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

AIRBUS HELI COPTERS



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 FWD Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102-09

Remaining Tasks to be Performed: Drill, clean up,  
straighten, inspect, powder coat.

Signature: David Prutz

Date: August 21/2017 Lic. No. / SCA 730409

In Process



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

**In Process**

**Remarks**

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## Aero Design

### Parts Distribution Sheet

AIRBUS HELICOPTERS  
21 SEPT 2017

Description: Beam Pin

WO# 2017-102

[illegible]

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0382</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>2</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.			<del>14a. <input type="checkbox"/> CAR 571.10 Maintenance Release</del> <del><input type="checkbox"/> Other regulation specified in block 12</del> <del>Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.</del>		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		<del>14b. Signature</del> <del>14c. Approved Organization Number</del>	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>12 Oct 2017</b>		<del>14d. Name</del> <del>14e. Date (dd/mmm/yyyy)</del>	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

*BIGHORN HELICOPTERS*



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: FWD Beam AS350 No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102-13

Remaining Tasks to be Performed: Straighten, clean up,  
powder coat, assemble, inspect.

Signature: David Marty

Date: Aug 28 / 2017 Lic. No. / SCA AD 78-04 03

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

### Remarks

In Process

Powder Coat 17055





WO# \_\_\_\_\_

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: FWD Beam AS350 No. of pieces: 1

Manufacturer: Aero Design Ltd

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102-12

Remaining Tasks to be Performed: Straighten, clean up, powder  
coat, assemble, inspect.

Signature: [Signature]

Date: Aug 28 / 2017 Lic. No. / SCA [Stamp]

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**In Process**

**Remarks**

Powder Cont 170FS



WO#

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013



1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0388</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>2</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>17 Oct 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

*Zimmer Air Services*



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: FWD Beam A5350 No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102-14

Remaining Tasks to be Performed: Straighten, clean up,  
powder coat, assemble, inspect.

Signature: David Muntz

Date: Aug 28 / 2017 Lic. No. / SCA NO 73-04 05

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**In Process**

**Remarks**

*Powder Coat 17055*



Description: Beam Pin

[illegible]

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: FWD Beam AS350 No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102-15

Remaining Tasks to be Performed: Straighten, clean up,  
powder coat, assemble, inspect.

Signature: [Signature]

Date: Aug 28/2015 Lic. No. / SCA AD 73-04 03

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

In Process

Remarks

Powder Coat 17085

16/10/2017



Description: Beam Pin

WO# 2017-102

[illegible]

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0401</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks <b>Black</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<del>14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12  Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.</del>		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		<del>14b. Signature 14c. Approved Organization Number</del>	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>26 Oct 2017</b>		<del>14d. Name 14e. Date (dd/mmm/yyyy)</del>	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.  Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.  Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

**ARROW HELICOPTERS**





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Fwd. Beam No. of pieces: 1  
Manufacturer: Aero Design Ltd.  
Part No.: 78635-01-00 Serial/Batch No.: NA  
TTSN: NA TSO: NA Rem.: NA  
Work Order No.: 2017-102  
Remaining Tasks to be Performed: ST DPM See reverse.

Signature: [Signature] NO  
Date: Sept. 13/2015 73-04  
Lic. No. / SCA 05

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

In Process

Remarks

Step 8 ✓  
9 ✓

10.

PO 17088

11.

A

Description: Beam Pin

[illegible]



**Description:** Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0407</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12  Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mm/yyyy) <b>06 Nov 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: FWD Beam AS350 No. of pieces: 1

Manufacturer: Aero Design Ltd

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102-16

Remaining Tasks to be Performed: Straighten, clean up,  
powder coat, assemble, inspect.

Signature: David Muntz

Date: Aug 28 / 2017 Lic. No. / SCA 73-04  
08

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**In Process**

**Remarks**

Powder Coat 170g5

## Aero Design

### Parts Distribution Sheet

## AVIA SERVICE

06 Nov 2017

Description: Beam Pin

WO# 2017-102

[illegible]

WO#

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0429</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12  Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>22 Nov 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

**SELKIRK MOUNTAIN HELI**





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 Fwd Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102

Remaining Tasks to be Performed: See reverse.

Signature: [Signature]

Date: Oct 24 / 2017

Lic. No. / SCA 73-04  
05

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

In Process

Remarks

Steps: 8. ✓  
9. ✓  
10. ✓  
11. ✓

22 NOV 2017



WO# 2017-102

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013



WO# \_\_\_\_\_

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0412</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>2</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>08 Nov 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

**TURISMO BORRACU**





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Fwd. Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102

Remaining Tasks to be Performed: See reverse.

Signature: David Marty

Date: Sept. 13/2017 Lic. No. / SCA AD 73-04 05

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

In Process

Remarks

Step: 8. ✓

9. ✓

10.

PO 17088

11.

28 Nov 2017



**Description:** Beam Pin

WO# 2017-102

[illegible]

## Aero Design

### Parts Distribution Sheet

**Description:** Beam Pin

WO#[illegible]



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: FWB Beam AS350 No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102-17

Remaining Tasks to be Performed: Straighten, clean up,  
powder coat, assemble, inspect.

Signature: David King

Date: Aug 28 / 2017 Lic. No. / SCA 73-04  
06

In Process





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

In Process

Remarks

Powder Cont Po 17255

08 NOV 2017



**Description:** Beam Pin

WO# 2017-102

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



**Description:** Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0422</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>20 Nov 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

**ACCESS HELICOPTERS**



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Fwd. Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102

Remaining Tasks to be Performed: See reverse.

Signature: David Mart

Date: Sept. 13/2015 Lic. No. / SCA 73-04 05

In Process





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

In Process

Remarks

Step: 8. ✓

9. ✓

10. ✓

11. ✓

FO 17088

**Description:** Beam Pin

WO# 2017-102

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



**Description:** Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0438</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mm/yyyy) <b>24 Nov 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

*Micro Flight Australia*



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 Fwd Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102

Remaining Tasks to be Performed: See reverse.

Signature: David May

Date: Oct 24 / 2017

Lic. No. / SCA 73-04  
08

In Process





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

### Remarks

Steps: 8 ✓

9 ✓

10 ✓ 2017125

11

24 Nov. 2017



**Description:** Beam Pin

WO# 2017-102

[illegible]



**Description:** Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No. <b>2017-0441</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mm/yy) <b>30 Nov 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

*Wilderness Helicopters*



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 Fwd. Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102

Remaining Tasks to be Performed: See reverse.

Signature: David Marty

Date: Oct 24 / 2017

Lic. No. / SCA 73-04  
05

In Process





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 8. ✓

9. ✓

10. ✓ P2 17105

11.

Description: Beam Pin

[illegible]



**Description:** Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0432</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12  Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>24 Nov 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

Regaviation



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 Fwd. Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102

Remaining Tasks to be Performed: See reverse.

Signature: David Marty

Date: Oct 24/2017 Lic. No. / SCA 7304 03

In Process





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

In Process

### Remarks

Steps: 8. ✓

9. ✓

10. ✓

to 17105

11.

24 Nov 2017



Description: Beam Pin

WO# 2017-102

[illegible]



**Description:** Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0435</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-102</b>
6. Item <b>1.</b>	7. Description <b>Forward Beam</b>	8. Part Number <b>78635-01-00</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>N/A</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12  Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the <del>Canadian Aviation Regulations</del> .		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>24 Nov 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

Helisu



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 Fwd Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78635-01-00 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-102

Remaining Tasks to be Performed: See reverse.

Signature: [Signature]

Date: Oct 24/2017

Lic. No. / SCA 73-04  
05

In Process





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**In Process**

### Remarks

Steps: 8. ✓

9. ✓

10. ✓

PO 17/08

11.

24 Nov. 2017



Description: Beam Pin

WO# 2017-102

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



**Description:** Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013